

Date: Tuesday, 12/6/2005 9:24:48 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOOR PROTCOR AFT LH
Job Number :	25122		
Estimate Number :	11228		
P.O. Number :	N/A	Part Number :	D32813
This Issue :	12/6/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3281 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	B
	Type :	Material :	N/A
		Due Date :	12/30/2005
Written By :	SEE COMMENT BELOW		
Checked & Approved By :	SEE COMMENT BELOW		
Comment :	Est Rev:A 04.07.01 New issue KJ/JLM		

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 192

Description: Floor Protector RH

Possible Supplier: Delastek

Certificate of Conformity is required

u

05.12.06

PO 6/1/30

2.0	D32813	Floor Protector, Aft LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Floor Protector, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

PO 6/1/30

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

PO 6/1/30

20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PO 6/1/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/10

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/6/2005 9:24:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT LH

Job Number: 25122

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/01

(20)

DD 06/02/01

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

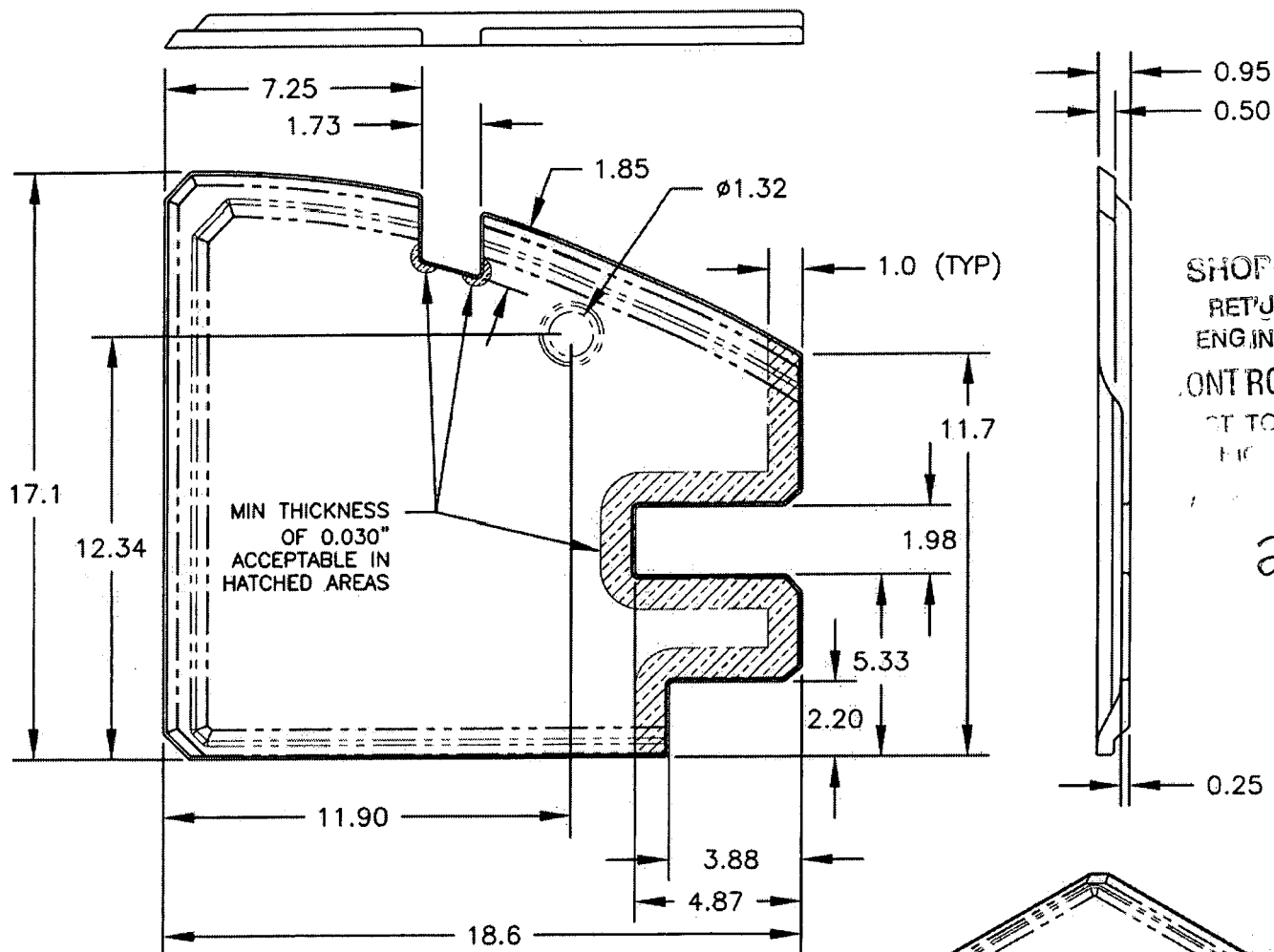
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	



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WITHOUT NOTICE

25122

RELEASED
05.12.01

D3281-1 FLOOR PROTECTOR, FWD LH

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN.

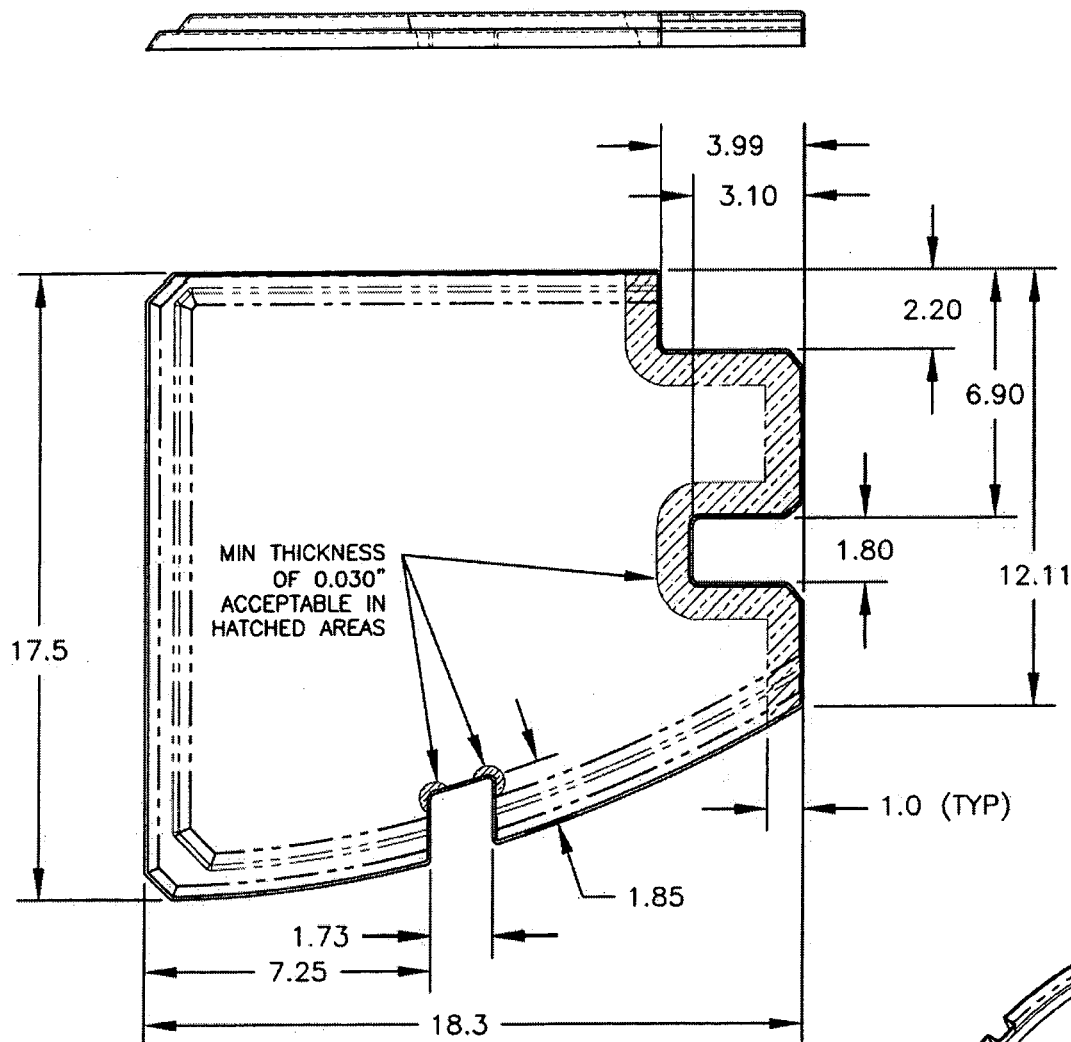
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

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WORK ORDER
NO 25122



RELEASED
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D3281-2 FLOOR PROTECTOR, FWD RH

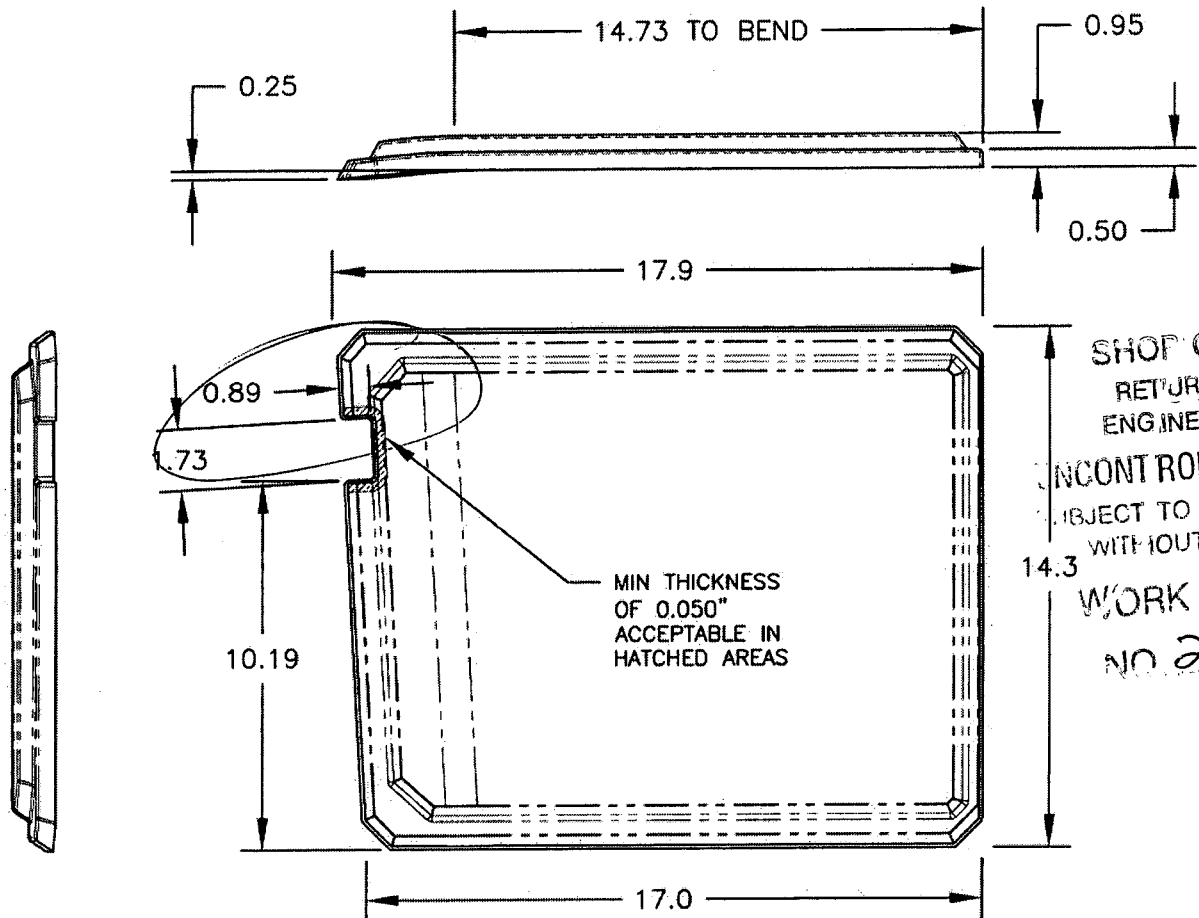
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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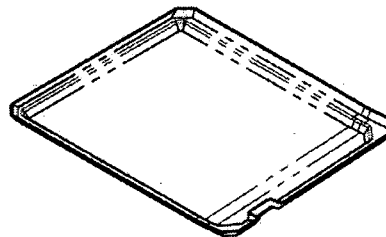
DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HL</i>	APPROVED <i>HL</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5



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WORK ORDER
NO. 25122

RELEASED
05.2.01. *HL*



D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	9876
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/01/06	05/12/05	4333	Linda Lacelle		PO00000192		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	0	20	DKC134-0044	Floor Protect Part 1 N° D3281-1 (F6006) Selon dessin D3181 Rev.: B JOB # 32263			
20	0	20	DKC134-0045	Floor Protect Part 2 N° D3281-2 (F6006) Selon dessin D3181 Rev.: B JOB # 32264			
20	0	20	DKC134-0046	Floor Protect Part 3 N° D3281-3 (F6006) Selon dessin D3181 Rev.: B JOB # 32265			
20	0	20	DKC134-0047	Floor Protect Part 4 N° D3281-4 (F6006) Selon dessin D3181 Rev.: B JOB # 32266			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR AFT, LH	
Numéro Job : 32265		Numéro Article : DKC134-0046	
Numéro Soumission : 2385		Numéro Dessin : D3281	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2005-12-21	No. B.V. :	Révision dessin : B	
Prsht Rev. : NC		Matériel : F6006	
Prem. fois : - -	Type :	Date Dûe : 2005-12-28	Qté: 20 Udm: UNITE
Job précédente : 32057			

Écrit par : _____

Vérifié & Approuvé par : _____

Commentaires : N° de pièce: D3281-3
Process Sheet Rév.: 00

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 APL0016 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE(s)/Unit Total:
Lexan F6006 Noir N° 700 48" x 96" x .12

N° de Lot: _____

APL0016



Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Bon achat: 5327

SÉCHAGE / ANEALING

2.0 SÉCHAGE/ ANEAL



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 4714

3.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 20 Date: 16-1-06 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____



Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 32265

Numéro Article: DKC134-0046

v Numéro Job:



Séq.:

Machine ou Opération:

Description :

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-3 à l'aide du moule N° D3281-3T1 sur le
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 20 Date: 16-1-06 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

F.O: 16jan 06



5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
TRIMAGE PLASTIQUE DART

- ① Faire le trimage du " Floor Protector " N° D3281-3 à l'aide du gabarit de trimage N° D3281-3T2. F.O: 17jan 06
- ② Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

① Quantité: 20 Date: 18/01/06 Sceau: _____② Quantité: 20 Date: 23/01/06 Sceau: _____

6.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 20 Date: 26jan 06 Sceau: _____

7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 32265

Numéro Article: DKC134-0046

* Numéro Job:



Séq.:

Machine ou Opération:


Description :

N° de pièce: D3281-3

N° de Job: _____

Date de fabrication: _____

Sceau d'inspection.

Quantité: 20 Date: 24-01-06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE




Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-3

Date de fabrication: _____

N° de job: _____

Quantité: 20 Date: 26/1/06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____